

Date: Monday, 6/5/2006 7:47:37 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY		
Job Number	: 27370					
Estimate Number	: 10280					
P.O. Number	: N/A		Part Number	: D3137043		
This Issue	: 6/5/2006 S.O. No. : N/A		Drawing Number	: D3137 REV E		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: E		
Previous Run	: 26413		Material	: N/A		
Written By	: <i>See comment below</i>		Due Date	: 6/30/2006 Qty: 8 Um: Each		
Checked & Approved By	: <i>JL 06.06.06</i>					
Comment	: Est Rev A 04.02.18 New issue KJ/DS					

## Additional Product

Job Number:



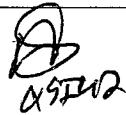
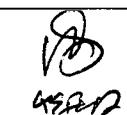
Seq. #:	Machine Or Operation:	Description :
1.0	M174B0500X02000	17-4 SS Bar <i>JL 06/07/24</i>
2.0	BAND SAW	BAND SAW <i>JL 06/07/24</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 <i>JL 06/07/24</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>JL 06/07/26</i>

**Comment:** BAND SAW  
 Cut blanks: (.500" x 2.000") 5.570" long

**Comment:** HAAS CNC VERTICAL MACHINING #1  
 1-Machine D3137-7 as per Folio FA3308 and Dwg D3137 Identify as D3137-7  
 2-Deburr  
 3-Scribe batch number

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/07/26	3	Part flew out of fixture		make sure part sits properly in JIG SCRAP-destory and Replace	J.G 06/07/26			
06/07/26	3	Part flew out of fixture		make sure pitbull clamps are well secured and part sits properly destroy SCRAP-destory and Replace	J.G 06/07/26			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/08/26

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:47:37 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27370

Part Number: D3137043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En 06/07/27 x 8

6.0 D31373 Guide



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3137-3 GUIDE B26888

MS 06/07/27 8

7.0 D31375 Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3137-5 Washer B27246

MS 06/07/27 8

8.0 MS24694S101 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS24694-s101 Screw M16941

MS 06/07/27 8

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3137-043 as per Dwg D3137

MS 06/07/27 8

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 06/07/27 x 8

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location:                   

RF 06/07/28 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:47:37 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27370

Part Number: D3137043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

8  
JP 06/07/31

Job Completion



8  
JP 06.07.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	27370
Description: Bracket		Part Number:	D3137-7
Inspection Dwg: D3137 Rev: E		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.435	+/-0.010	0.432	—			
0.615	+/-0.010	0.614	—			
0.200	+/-0.010	0.202	✓			
0.380	+/-0.010	0.381	—			
0.262	+/-0.010	0.264	✓			
Ø0.500	+0.005/-0.000	0.501	✓			
0.79	+/-0.030	0.803	✓			
2.79	+/-0.030	2.77	✓			
Ø0.560	+0.005/-0.000	0.560	—			
0.595	+/-0.010	0.596	—			
0.950	+/-0.010	0.946	✓			
0.605	+/-0.010	0.604	✓			
1.880	+/-0.010	1.893	—			
2.48	+/-0.030	2.497	✓			
4.975	+/-0.010	4.980	—			
5.41	+/-0.030	5.422	✓			
0.032	+/-0.010	0.026	✓			
0.063	+/-0.010	0.063	✓			
R0.062	+/-0.010	6.062	✓			
0.162	+/-0.010	0.152	✓			

Measured by:	Ep/S.G	Audited by:	gnf	Prototype Approval:	N/A
Date:	06/07/27	Date:	06/07/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3137-043	KJ/RF	
B	04.06.15	Changed & added dimensions	KJ/JLM	
C	06.03.15	Dwg Rev update	KJ/JLM	

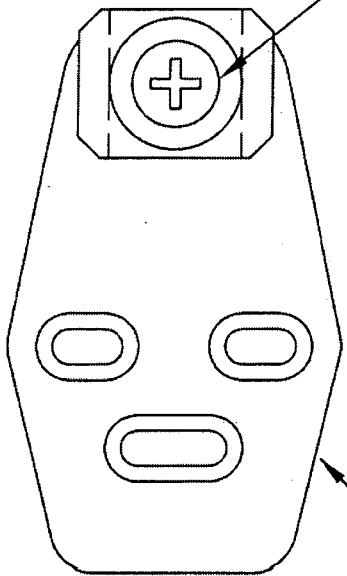
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DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:1

**RELEASED**  
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A	02.04.17	NEW ISSUE
B	03.01.16	ADD RIDGES; ADD MAT'L PROP.
C	03.08.15	ADD -043
D	04.11.03	RE-DESIGN D3137-5; CHANGE DIMS
E	05.11.23	ADD -045

MS24694-S101 SCREW  
D3137-5 WASHER  
D3137-3 GUIDE  
INSTALL ON SAME SIDE AS C'SINKS  
(OPPOSITE SIDE FROM RIDGES)



D3137-1 BRACKET (-041 SHOWN)  
OR  
D3137-7 BRACKET (-043 SIMILAR)  
OR  
D3137-9 BRACKET (-045 SIMILAR)

D3137-041 BRACKET ASSEMBLY (SHOWN)  
D3137-043 BRACKET ASSEMBLY (SIMILAR)  
D3137-045 BRACKET ASSEMBLY (SIMILAR)

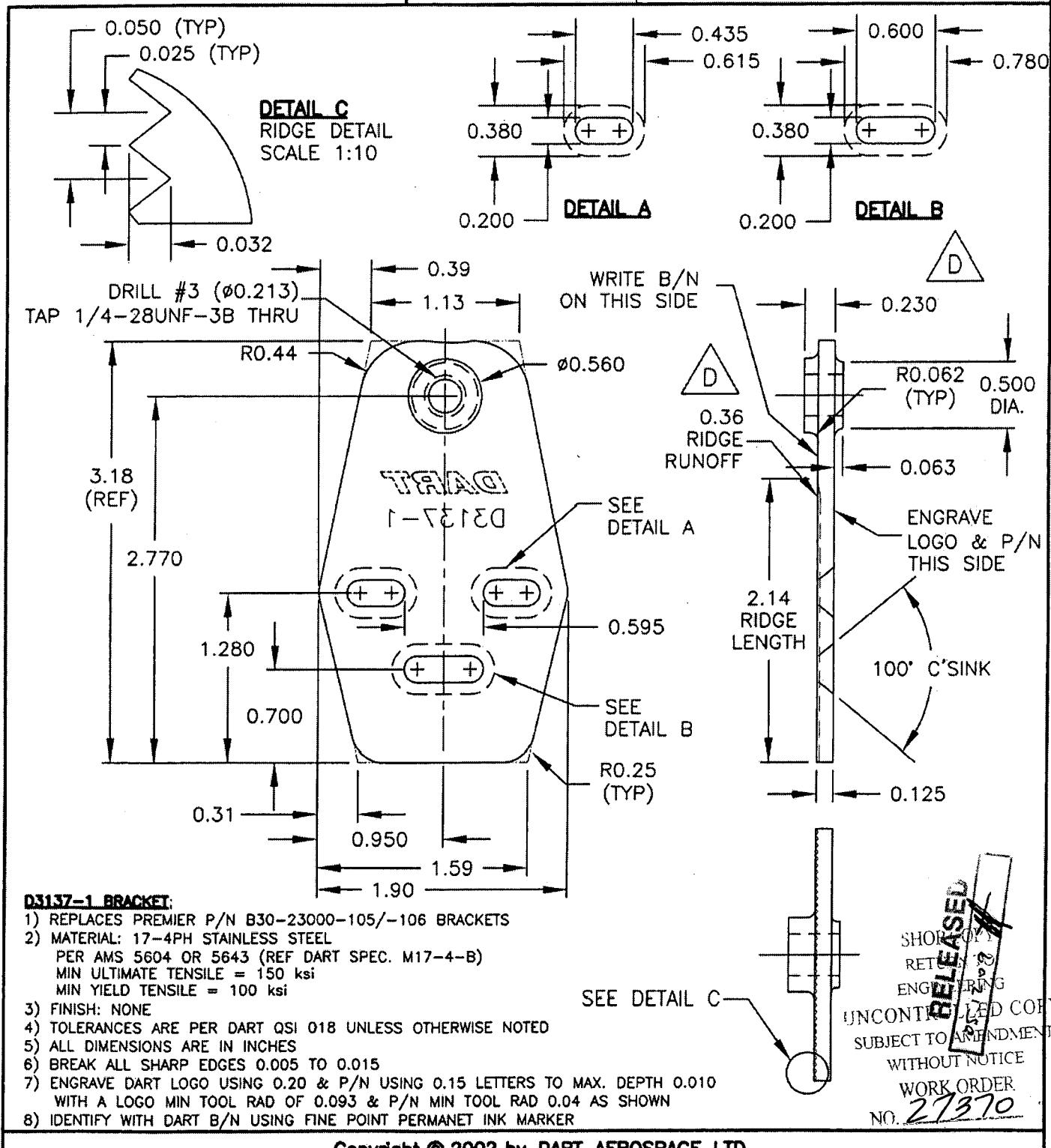
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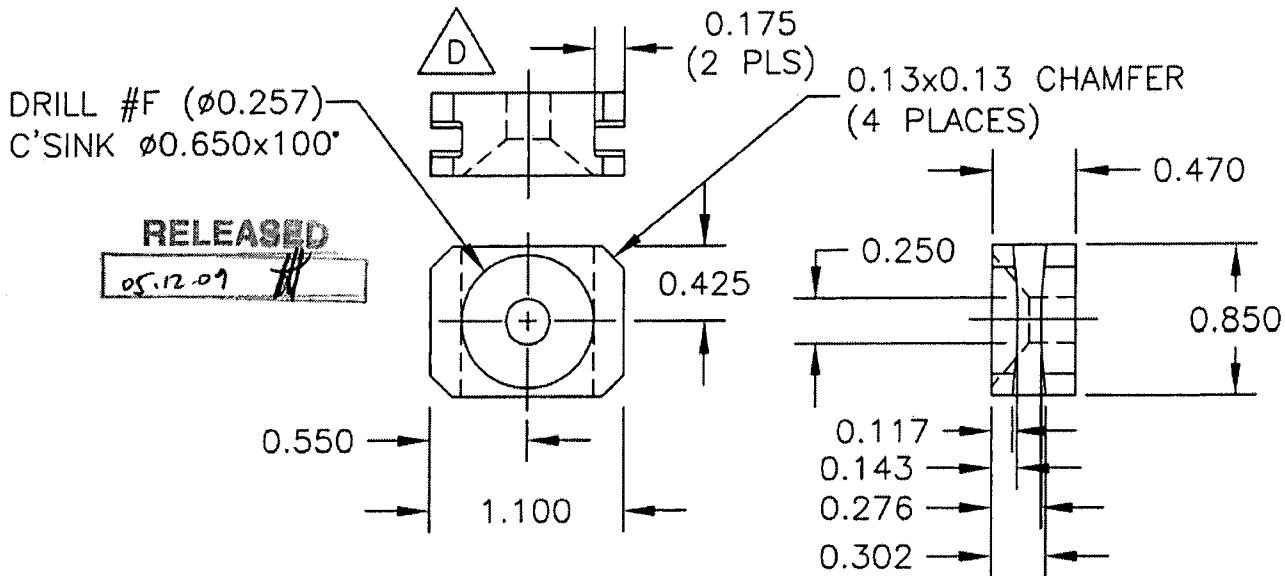
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DATE <b>05.11.23</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE <b>1:1</b>



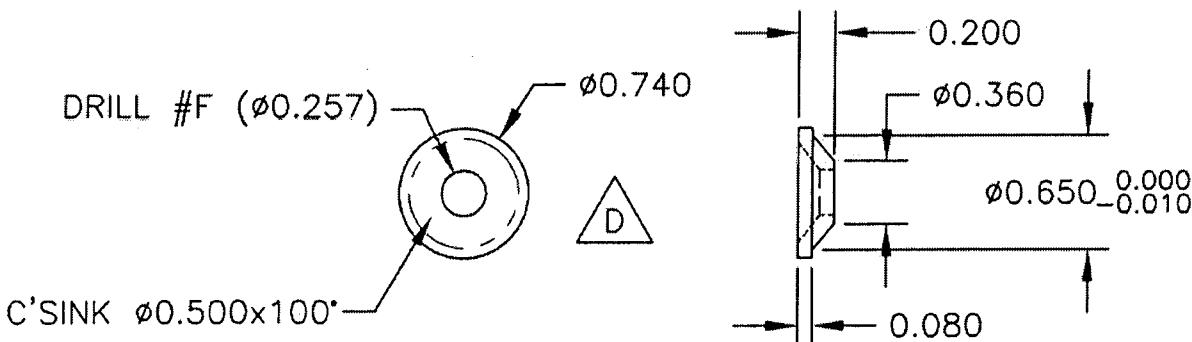
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DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3137-3 GUIDE**

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015

**D3137-5 WASHER**

- 1) REPLACES PREMIER P/N B30-23000-209
- 2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPEC. M6061T6R)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL EDGES 0.005 TO 0.015

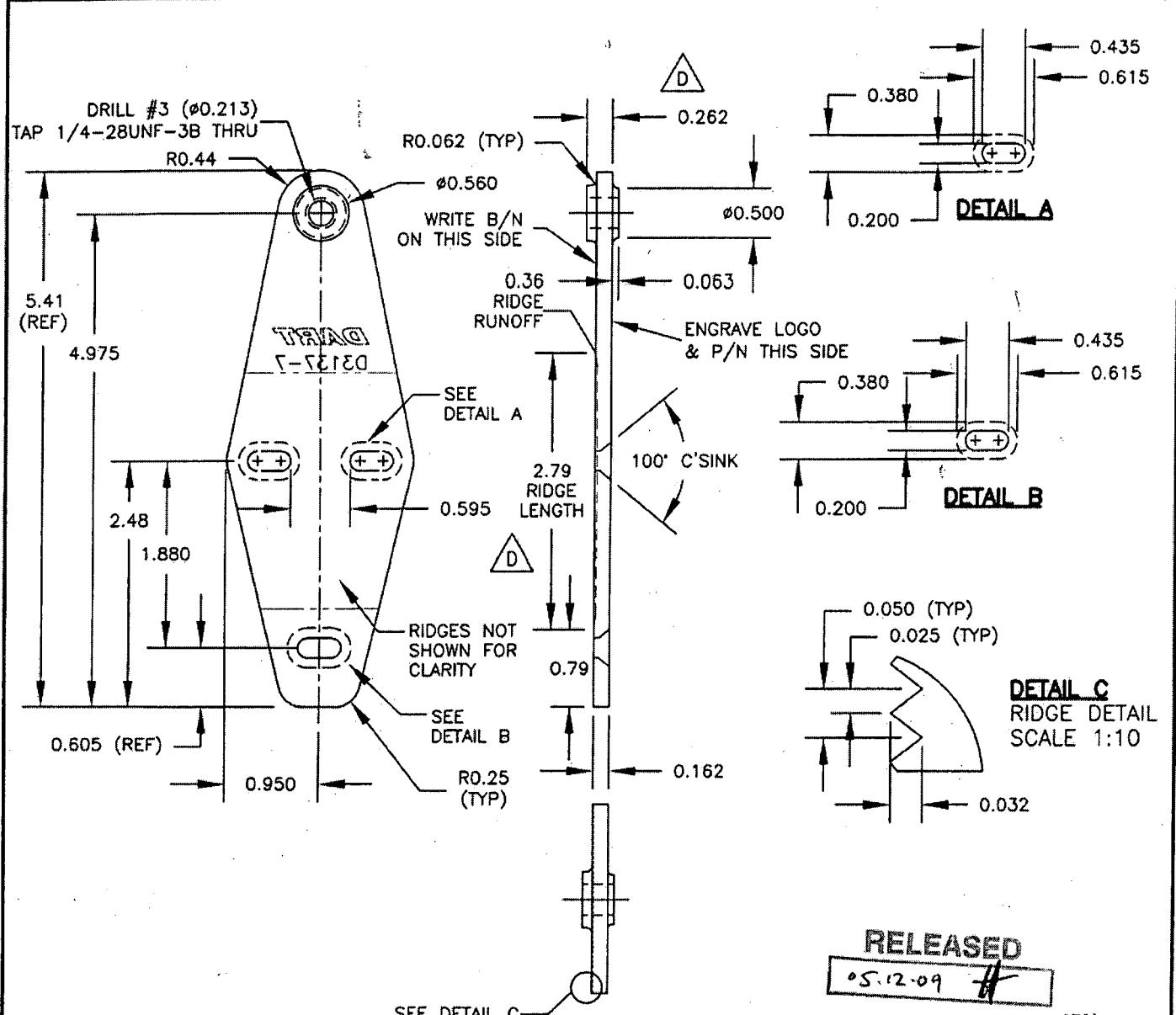
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DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 2:3

**D3137-7 BRACKET:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART LOGO USING 0.20" & P/N USING 0.15" LETTERS TO MAX. DEPTH 0.010  
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 7) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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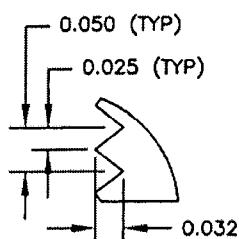
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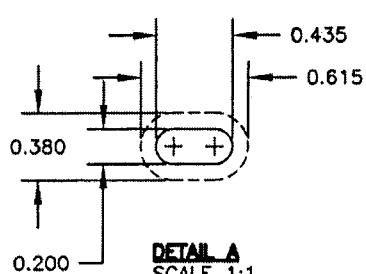
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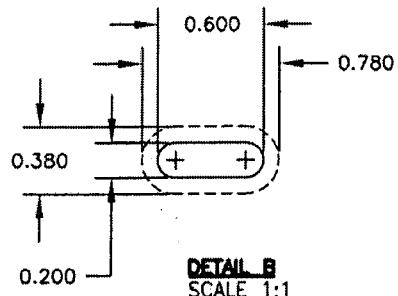
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DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:2



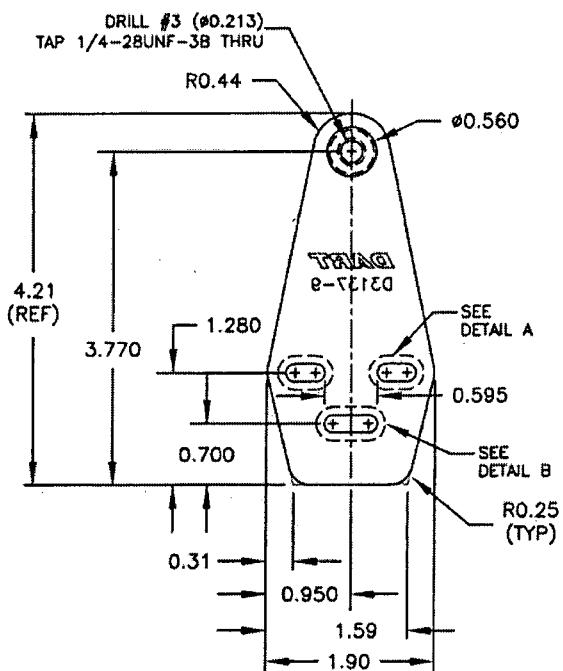
**DETAIL C**  
RIDGE DETAIL  
SCALE 1:20



**DETAIL A**  
SCALE 1:1



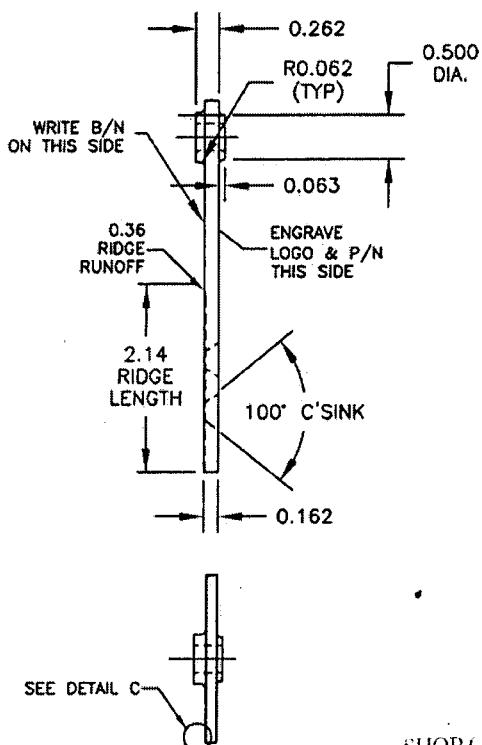
**DETAIL B**  
SCALE 1:1



**E**

**D3137-9 BRACKET:**

- 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
- 2) MATERIAL: 17-4PH STAINLESS STEEL  
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010  
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 8) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER



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